

# Work Order ID 65871

Wednesday, January 26, 2011 1:48:08 PM

Page 1

Item ID: D3240-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Frame

Start Date: 1/26/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: RP Date: 1-01-26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3240	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3240 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

2074 .063

B11-3-4

(21)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-3-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/1/04

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65871**

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Item ID: D3240-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									

H BL 11-3-8.

4 d M 11/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 65871**

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Wednesday, January 26, 2011 1:48:08 PM

Item ID: D3240-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location 217

0.00



Packaging

Memo

0.00

Packaging

11/3/09 SL (40)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/09 SL11-03-9  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, January 26, 2011 1:48:14 PM

Page 1

Work Order ID: 65871

Parent Item: D3240-1

Parent Item Name: Frame





Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 05.04.28 Added Step 6 & 7 KJ/JLM  
IPP Rev C now water jet 07-11-01 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased				110	sf	55.9270	2.534	10.66947			
											HB 11-3-4		

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT22

55.927

114351

55.927

117018

117018

4

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3240	REV. B SHEET 1 OF 1
DATE 05.01.06		TITLE FRAME	SCALE NTS
A	03.12.18	NEW ISSUE	
B	05.01.06	25.50 WAS 25.19; 14.31 WAS 14.19	

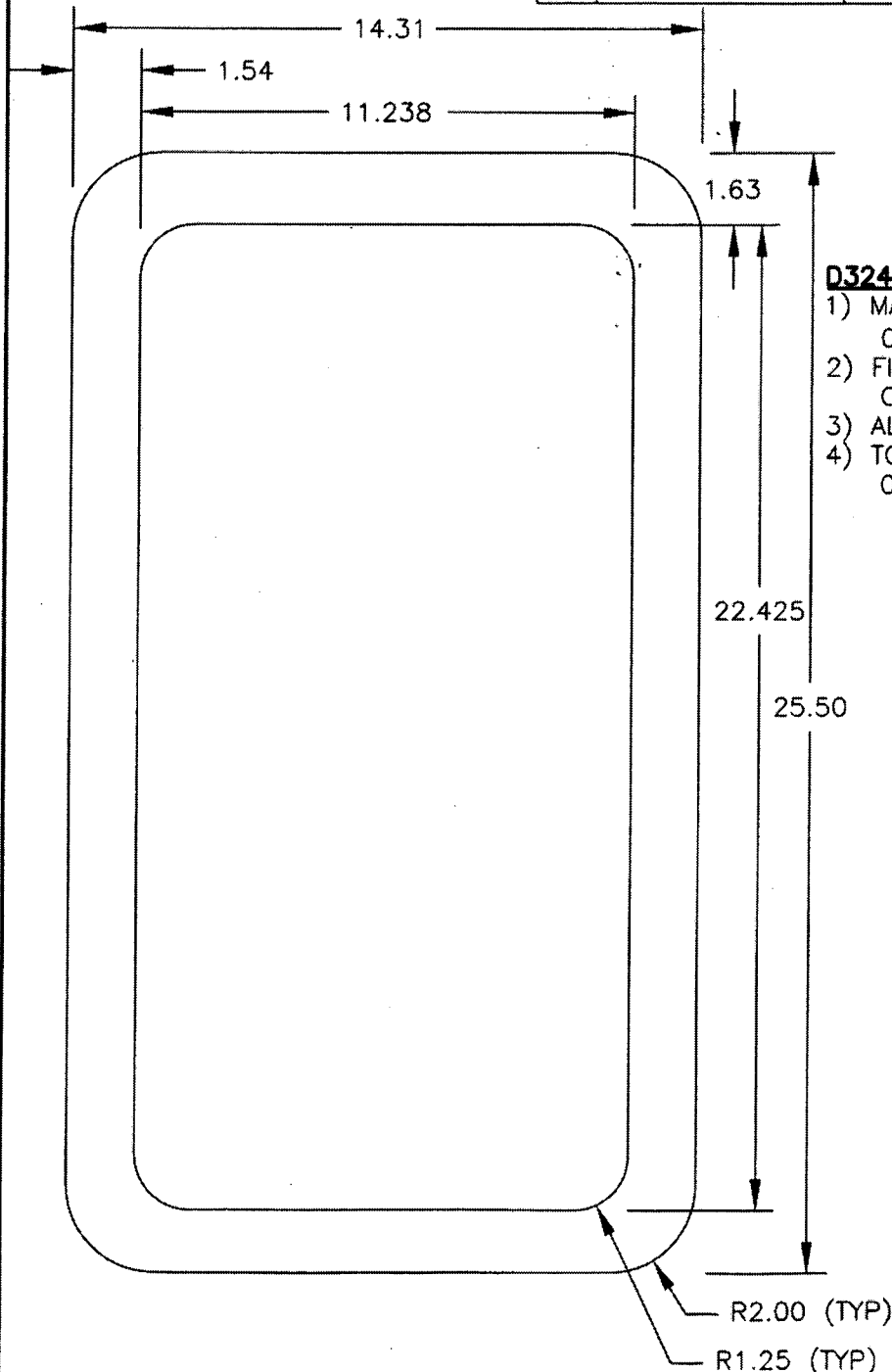
RELEASED  
05.02.02

**D3240-1 FRAME**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 45871

*BS11-0124*



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